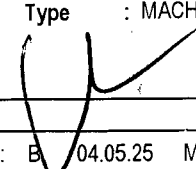


Date:
Order:Monday, 11/19/2007 4:02:29 PM
Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : FILLER
Job Number : 35832	
Estimate Number : 10782	
P.O. Number : N/A	Part Number : D32087
This Issue : 11/19/2007 S.O. No. : N/A	Drawing Number : D3208 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A	Drawing Revision : A
Previous Run : 21792	Material : N/A
Written By : 	Due Date : 12/2/2007
Checked & Approved By : _____	Qty: 12 Um: Each
Comment : Est: B 04.05.25 Material changed for Step 4 KJ/JLM	

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 M2024T3S040 M2024T3S040 6001-16.040 Sheet



sel drag



Comment: Qty.: 0.0947 sf(s)/Unit Total: 1.1365 sf(s)

Material: 2024-T3 (QQ-A-250/4) 0.040" thick

(M2024T3S.040)

Batch: M103039 (11x) M106272 (12)

2.0

SHEAR

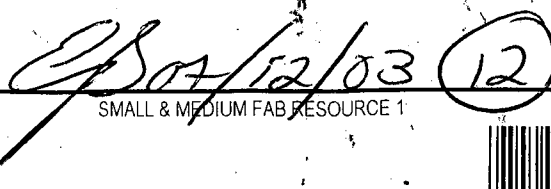
SHEAR



Comment: SHEAR

Cut blank: 2.750" x 4.300"

Identify for D3208-7

 08/12/03 (12)

3.0

SMALL FAB 1

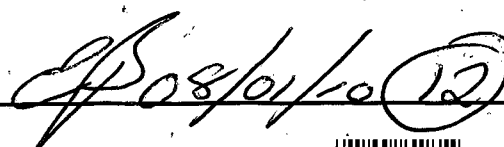
SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Drill and Fillet D3208-7 corner as per Dwg D3208

Identify as D3208-7

 08/01/10 (12) SB

4.0

BRAKE NC

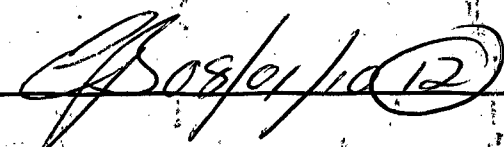
NC BRAKE



Comment: NC BRAKE

Deburr D3208-7

Polish any marks on part within 01. of Dwg D3208

 08/01/10 (12) SB

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 08/01/16
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 11/19/2007 4:02:29 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FILLER

Job Number: 35832

Part Number: D32087

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/01/10 (412)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M-1 08/01/10

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

8/1/15 SP (2X)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 176

8/1/15 (2X) SP

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

12/08/01/10

Job Completion



08/01/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

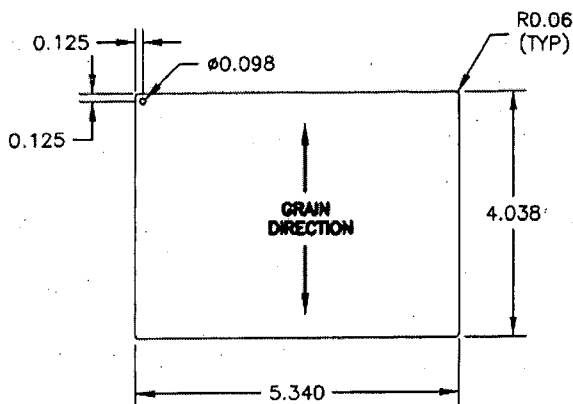
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

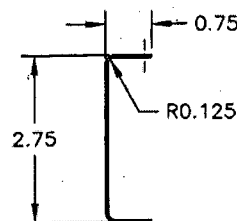


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CHECKED #	APPROVED #	DRAWING NO. D3208	REV. A SHEET 1 OF 3
DATE 04.01.27		TITLE DOUBLER	SCALE 1:3
A	04.01.27	NEW ISSUE	
AI	# 04.05.25	CHANGE DIM; NOTE 3) CHANGE	

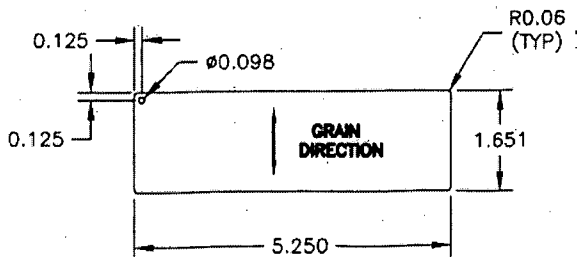
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04.04.05



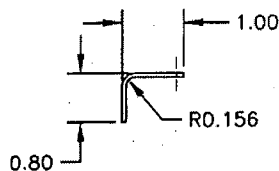
2 D3208-1 DOUBLER
FLAT PATTERN



D3208-1 DOUBLER
BEND DETAIL



3 D3208-3 PEDAL MOUNT ANGLE
FLAT PATTERN



D3208-3 PEDAL MOUNT ANGLE
BEND DETAIL

NOTES:

- 1) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040" THICK (M2024T3S.040)
- 3) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063" THICK (M2024T3S.063)
- 4) MATERIAL: 2024-T3 (QQ-A-250/4) 0.080" THICK (M2024T3S.080)
- 5) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES
- 3) MATERIAL: 6061-T6 (QQ-A-250/11) 0.063" THICK (M6061T6S.063)



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WORK ORDER
NO 35832

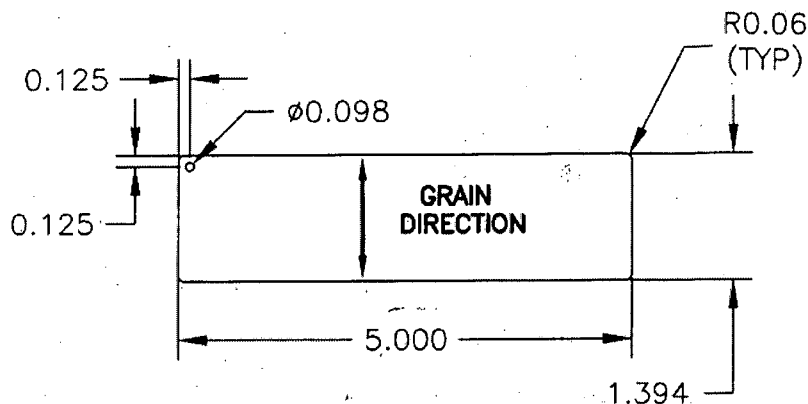
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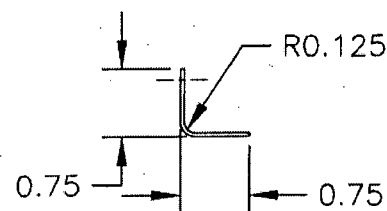


DESIGN H	DRAWN BY H	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3208	REV. A SHEET 2 OF 3
DATE 04.01.27		TITLE DOUBLER	SCALE 1:2

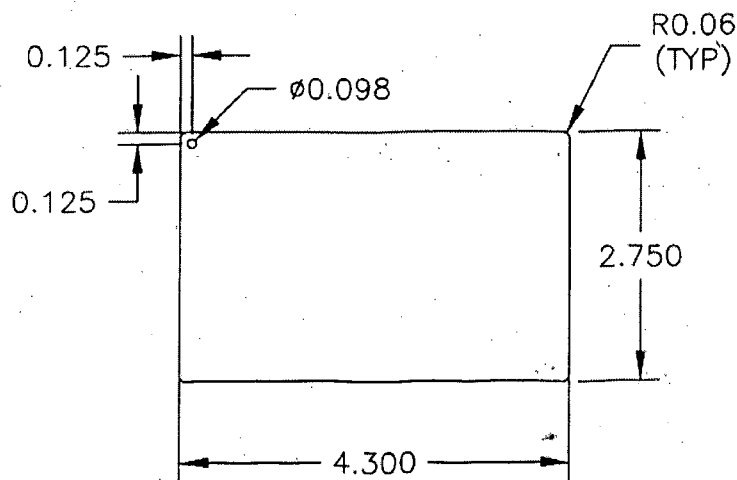
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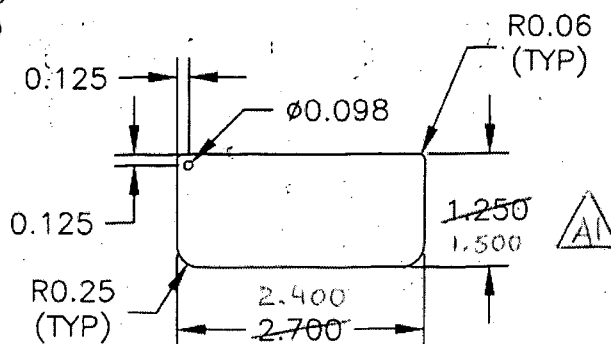
**D3208-5 MOUNT ANGLE
FLAT PATTERN**



**D3208-5 MOUNT ANGLE
BEND DETAIL**



D3208-7 FILLER



D3208-11 FILLER

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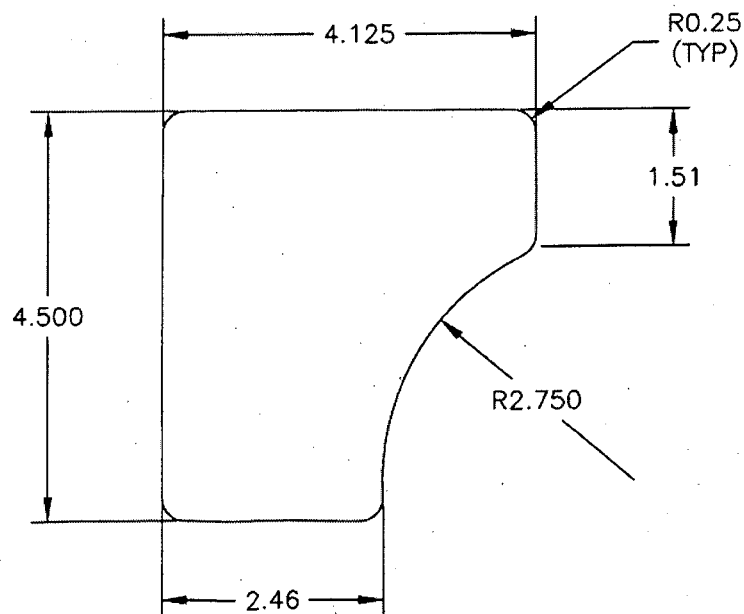
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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3208	REV. A SHEET 3 OF 3
DATE 04.01.27		TITLE DOUBLER	SCALE 1:2

RELEASED
04.04.05 of



D3208-9 DOUBLER

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